

ARTICLE 34

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1. Method for welding together two bodies, for instance pipes or plates, which are placed mutually in line against each other while leaving clear a weld groove, wherein the weld groove is filled with more than 5 one welding layer by means of a welding torch moved in longitudinal direction of the weld groove, characterized in that two welding layers are laid in one welding pass by means of two welding torches placed successively at a predetermined fixed distance in the longitudinal 10 direction of the weld groove and that two carriers each having two welding torches are moved in peripheral direction of the bodies.

2. Method as claimed in claim 1, wherein the weld groove has outward diverging walls, characterized in that 15 at least the trailing welding torch performs an oscillating movement.

3. Method as claimed in claim 2, characterized in that the trailing welding torch is oscillated at a greater amplitude than the leading welding torch.

20 4. Method as claimed in claim 3, characterized in that the trailing welding torch is oscillated at a frequency differing from that of the leading welding torch.

5. Method for welding together two pipes as claimed 25 in any of the preceding claims, characterized in that each carrier is moved per welding pass over half a peripheral part of the pipes.

6. Method as claimed in claim 5, characterized in that each carrier is moved per welding pass in downward 30 peripheral direction of the pipes.

7. Device for welding together two bodies, for instance pipes or plates, which are placed mutually in line against each other while leaving clear a weld groove, comprising a carrier for a welding torch guidable 35 in longitudinal direction of the weld groove, characterized by at least two carriers each having at

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least two welding torches lying successively in the longitudinal direction of the weld groove.

8. Device as claimed in claim 7, wherein the weld groove has outward diverging walls, characterized by means for moving at least each trailing welding torch reciprocally in transverse direction of the weld groove.

9. Device as claimed in claim 8, characterized in that these means are formed by a shaft pin driven for reciprocal sliding in each carrier and connected to the respective welding torch.

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